

ASSEMBLING
AND USING
YOUR

Heathkit

IMPEDANCE
BRIDGE
MODEL IB-2

596-50

HEATH COMPANY

BENTON HARBOR,
MICHIGAN

PRICE \$1.00

THE WORLD'S *Finest* TEST EQUIPMENT IN KIT FORM

STANDARD COLOR CODE — RESISTORS AND CAPACITORS

AXIAL LEAD RESISTOR

Brown — Insulated
Black — Non-insulated



Wire wound resistors have
1st digit band double width

INSULATED
UNINSULATED
Color

BLACK
BROWN
RED
ORANGE
YELLOW
GREEN
BLUE
VIOLET
GRAY
WHITE

FIRST RING
BODY COLOR
First Figure

0
1
2
3
4
5
6
7
8
9

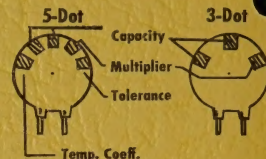
SECOND RING
END COLOR
Second Figure

0
1
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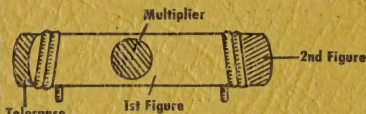
THIRD RING
DOT COLOR
Multiplier

None
0
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000
0,000
00,000
000,000
0,000,000
00,000,000
000,000,000

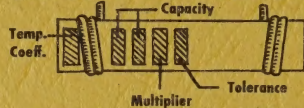
DISC CERAMIC RMA CODE



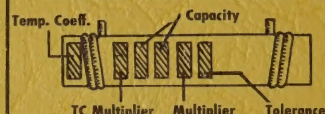
RADIAL LEAD DOT RESISTOR



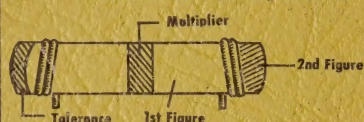
5-DOT RADIAL LEAD CERAMIC CAPACITOR



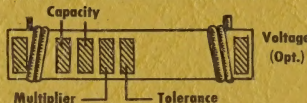
EXTENDED RANGE TC CERAMIC HICAP



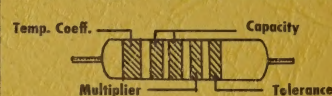
RADIAL LEAD (BAND) RESISTOR



BY-PASS COUPLING CERAMIC CAPACITOR



AXIAL LEAD CERAMIC CAPACITOR



The standard color code provides all necessary information required to properly identify color coded resistors and capacitors. Refer to the color code for numerical values and the zeroes or multipliers assigned to the colors used. A fourth color band on resistors determines tolerance rating as follows: Gold = 5%, silver = 10%. Absence of the fourth band indicates a 20% tolerance rating.

The physical size of carbon resistors is determined by their wattage rating. Carbon resistors most commonly used in Heathkits are $\frac{1}{2}$ watt. Higher wattage rated resistors when specified are progressively larger in physical size. Small wire wound resistors $\frac{1}{2}$ watt, 1 or 2 watt may be color coded but the first band will be double width.

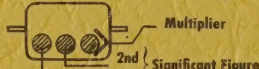
MOLDED MICA TYPE CAPACITORS

CURRENT STANDARD CODE

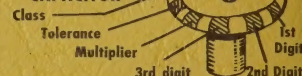


JAN &
1948
RMA
CODE

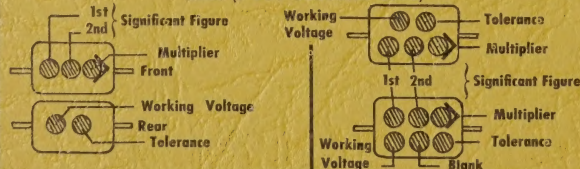
RMA 3-DOT (OBSOLETE) RATED 500 W.V.D.C. $\pm$ 20% TOL.



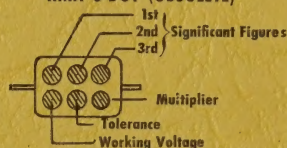
BUTTON SILVER MICA CAPACITOR



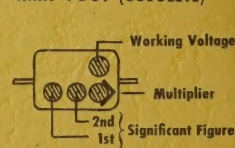
RMA (5-DOT OBSOLETE CODE)



RMA 6-DOT (OBSOLETE)

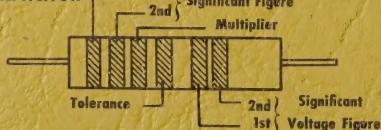


RMA 4-DOT (OBSOLETE)



MOLDED PAPER TYPE CAPACITORS

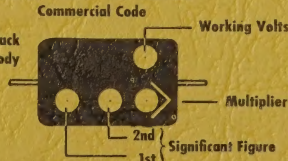
TUBULAR CAPACITOR



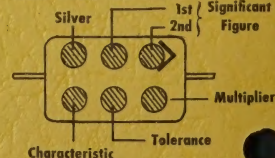
Normally
stamped for
value

A 2 digit voltage rating indicates more than 900 V.
Add 2 zeros to end of 2 digit number.

MOLDED FLAT CAPACITOR



JAN. CODE CAPACITOR

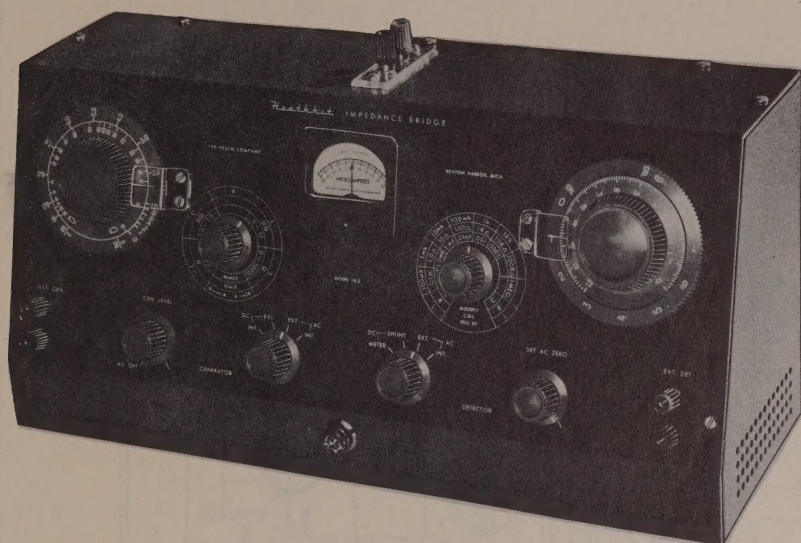


The tolerance rating of capacitors is determined by the color code. For example: red = 2%, green = 5%, etc. The voltage rating of capacitors is obtained by multiplying the color value by 100. For example: orange = 3×100 or 300 volts. Blue = 6×100 or 600 volts.

In the design of Heathkits, the temperature coefficient of ceramic or mica capacitors is not generally a critical factor and therefore Heathkit manuals avoid reference to temperature coefficient specifications.

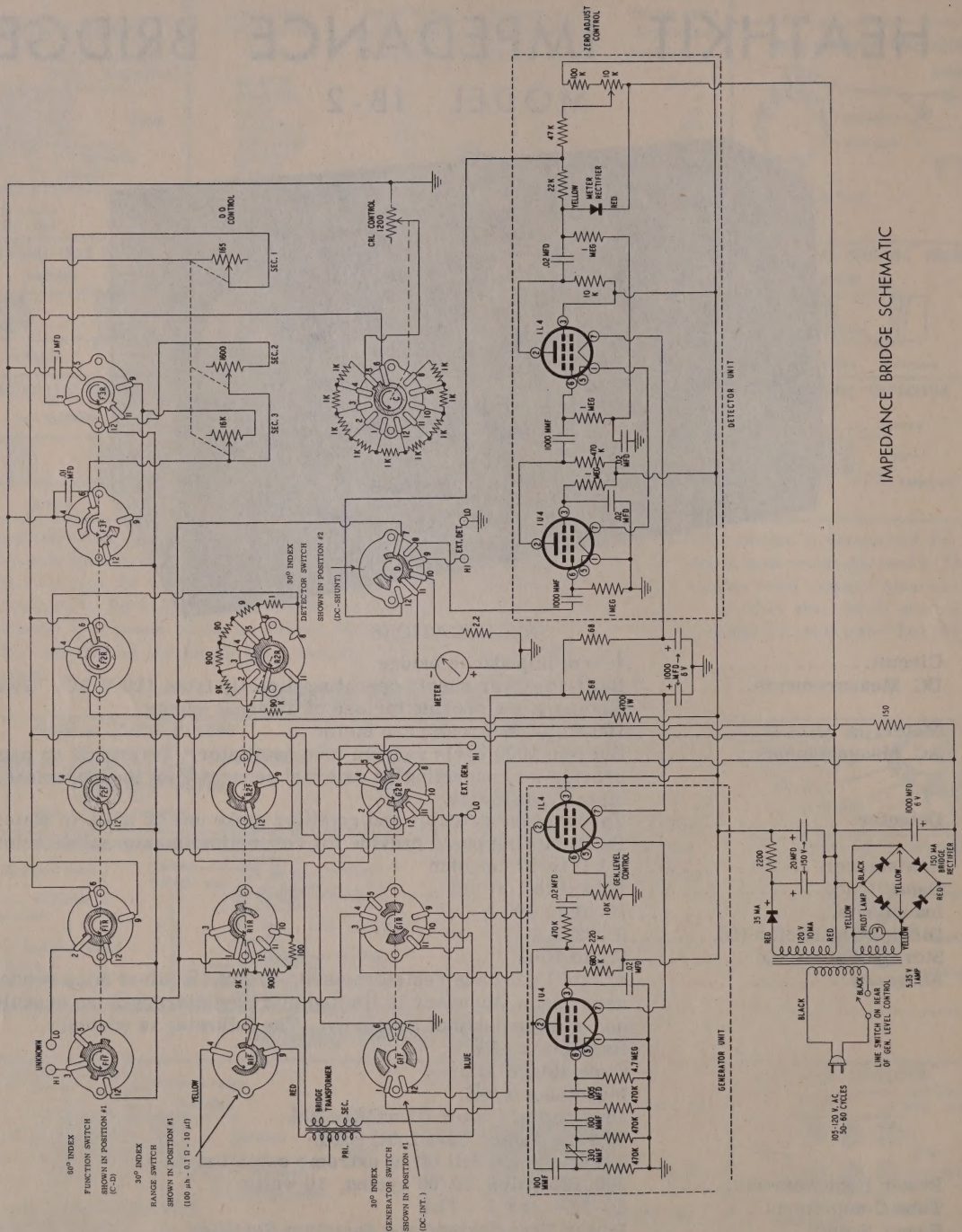
ASSEMBLY AND OPERATION OF THE HEATHKIT IMPEDANCE BRIDGE

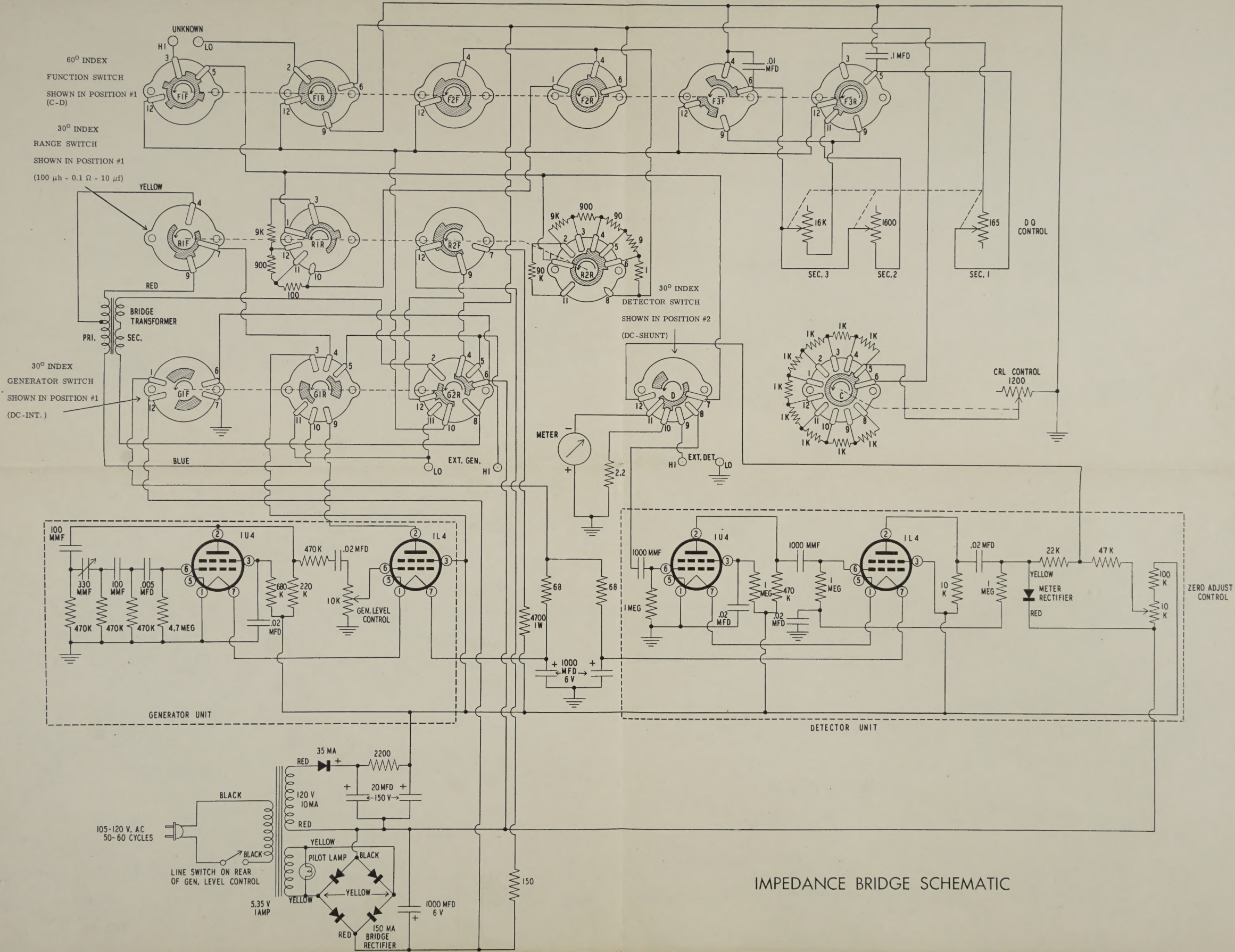
MODEL IB-2



SPECIFICATIONS

Circuit.....	4-arm impedance bridge
DC Measurements.....	Built-in power supply operating directly from 110 V AC. Panel binding posts provide for use of external supply.
Meter.....	100-0-100 microampere meter
AC Measurements.....	Built-in 1000 cycle vacuum tube oscillator. Terminals on panel provide for connecting an external generator for measurement at other frequencies.
Detector.....	Vacuum tube detector and rectifier make use of built-in meter. Panel binding posts provide for connection to external detector.
Resistance.....	0.1 Ω to 10 megohm
Capacitance.....	10 μf to 100 μf
Inductance.....	10 μh to 100 h
Dissipation Factor (D).....	0.002 to 1
Storage Factor (Q).....	0.1 to 1000
Accuracy.....	1/2 or 1% decade resistors used. 1/2 of 1% silver mica condensers used. Accuracy is limited more by interpretation of scales and workmanship of assembly. The following is normal: Resistance $\pm 3\%$ Capacitance $\pm 3\%$ Inductance $\pm 10\%$ Dissipation Factor ($D=wCR$) $\pm 20\%$ Storage Factor ($Q=wL/R$) $\pm 20\%$ Accuracy will fall off at extreme outer limits.
Power Requirements.....	105-125 volts, 50/60 cycles, 10 watts
Tube Complement.....	2 - 1J4 and 2 - 1L4
Power Supply.....	Power Transformer and Selenium Rectifier
Cabinet Size.....	8" high x 17" wide x 6" deep
Shipping Weight.....	15 lbs.





IMPEDANCE BRIDGE SCHEMATIC

GENERAL DESCRIPTION

The Heathkit model IB-2 Impedance Bridge is a self-contained, direct reading precision laboratory instrument designed for rapid and accurate measurement of resistance, capacitance, inductance, dissipation factors of condensers, and storage factors of inductors.

The Heathkit Impedance Bridge is a self-powered four-arm bridge of standard design for use in laboratories, service shops and schools. By use of switches, a number of basic bridge circuits are obtained.

Resistance is measured with an internal well filtered power supply operating directly from 105-120 volts AC, 50/60 cycles. This supply uses a transformer and selenium rectifiers.

A 100-0-100 microampere meter is used for determining balance. A 2.2Ω resistor is shunted across the meter for protection. This may be cut out for final balance.

A built-in vacuum tube adjustable phase shift generator supplies 1000 cycles for alternating voltage measurements. A trimmer condenser provides for setting the frequency of the oscillator by means of a laboratory standard if desired. Binding posts are available for connecting to an external generator for measurements at frequencies other than 1 kc. Battery type tubes are used so that a warming up period is not required and also to eliminate change in operating characteristics due to thermal effect.

The built-in vacuum tube detector unit and meter rectifier make possible the use of the meter for AC measurements thus making unnecessary the usual headset or other device for such measurements. Provision is made for using an external detector when desirable.

THEORY

A bridge is an arrangement of impedances used for measuring various electrical properties. When used for direct current measurement of resistance, the bridge generally takes the form of the Wheatstone bridge with four resistance arms. This is the standard method for the accurate measurement of resistance.

For the measurement of circuit constants at audio frequencies, the alternating-current bridge is the most widely used device. Measurements of inductance and capacitance are made conveniently and accurately by this method. The type of AC bridge circuit used is determined by the measurement to be made. These circuits are all adaptations of the fundamental Wheatstone bridge circuit.

A characteristic of a coil or condenser which is of importance and which can be measured conveniently on an AC bridge, is the ratio of resistance to reactance. This ratio is defined as the dissipation factor D, and its reciprocal is called the storage factor Q. The defining equations are as follows:

$$D = \frac{1}{Q} = \frac{R}{X} \qquad Q = \frac{1}{D} = \frac{X}{R}$$

where R and X are the series resistance and reactance of the inductance or capacitance being measured.

Dissipation factor is directly proportional to the energy dissipated per cycle and storage factor is directly proportional to the energy stored per cycle. Dissipation factor is more commonly used for condensers because it varies with the loss, while storage factor is more commonly used for inductors since it indicates the voltage step-up in a tuned circuit.

In its basic form the bridge consists of four impedance arms A, B, C, D. The ratio of A and B is adjustable so that the variable arm D serves as a standard for measuring many values at C. The four impedances are connected in series-parallel to a source of potential E between the junctions of A and C. When the voltage drop across arm A is equal to the voltage drop across arm C, no current will flow through the detector and the bridge is in balance. This condition of balance may be indicated by the formula:

$$\frac{A}{C} = \frac{B}{D}$$

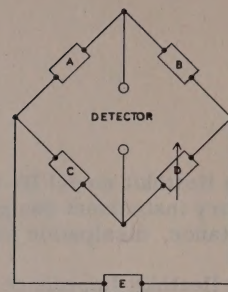


Figure 1

Two conditions are necessary for balance. Both the magnitudes of the impedances and the phase angles must be equal.

By the proper use of resistances, condensers, inductors or resistor-condenser combinations in series or parallel, the bridge may be used for measuring resistance, capacity, inductance, dissipation factor (D) and storage factor (Q).

In this bridge, selection of the various bridge combinations is made by setting the function switch to the proper position. The ratio arms of the bridge are controlled by the range switch. Balance is obtained by adjustment of the DQ and CRL dials.

RESISTANCE MEASUREMENTS

After over a century of use the Wheatstone bridge is still considered to be the fundamental circuit for the measurement of DC resistance. A Wheatstone bridge of four resistance arms, the fourth being the unknown, is used for resistance measurements. The basic equation of balance for the Wheatstone bridge is:

$$R_x = \frac{R_D R_A}{R_B}$$

R_D is read on the CRL control and the ratio R_A/R_B is read on the range dial. Thus the value of the unknown resistance is the product of the readings of the two dials.

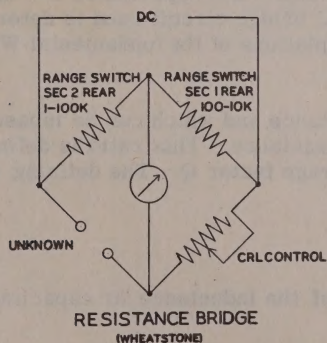


Figure 2

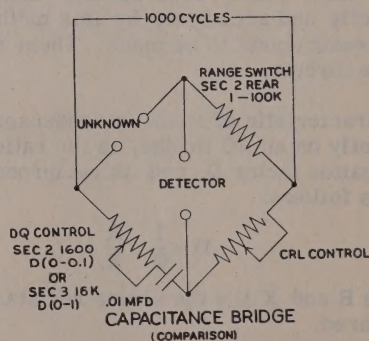


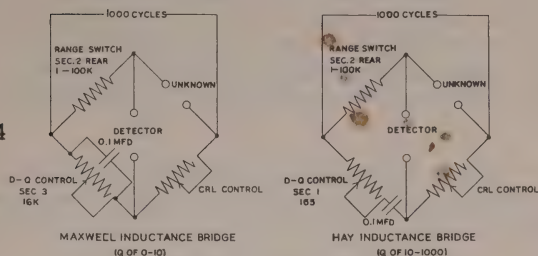
Figure 3

CAPACITY MEASUREMENTS

A Capacitance-Comparison bridge is used for the measurement of capacity. This circuit utilizes a standard condenser in series with a variable resistance. Dissipation factor is also measured with this circuit.

INDUCTANCE MEASUREMENTS

Figure 4



The Maxwell bridge is used for measuring inductances when the storage factor is below 10. In this bridge, inductance is measured in terms of capacitance. A condenser has some advantages as a standard as it gives practically no external field and is more compact.

For measuring inductances with storage factors between 10 and 1000, the Hay bridge is used. This is a modification of the Maxwell bridge. In the Hay bridge, the condenser is in series with the resistance, while in the Maxwell bridge, the condenser is in parallel with the resistance.

NOTES ON ASSEMBLY AND WIRING

The quality of parts and design of the Heathkit model IB-2 Impedance Bridge place it in the laboratory equipment class. When constructed in accordance with the instructions in this manual it will give many years of satisfactory service. We therefore urge you to take the necessary time to assemble and wire the kit carefully.

This manual is supplied to assist you in every way to complete the instrument with the least possible chance for error. We suggest you take a few minutes now and read the entire manual through before any work is started. This will enable you to proceed with the work much faster when construction is started. The large fold-in pictorials are handy to attach to the wall above your work space. Their use will greatly simplify the completion of the kit. These diagrams are repeated in smaller form within the manual. We suggest you retain the manual in your files for future reference, both in the use of the instrument and for its maintenance.

UNPACK THE KIT CAREFULLY AND CHECK EACH PART AGAINST THE PARTS LIST. In so doing, you will become acquainted with each part. Refer to the charts and other information shown on the inside covers of the manual to help you identify any parts about which there may be a question. If some shortage is found in checking the parts, please notify us promptly and return the inspection slip with your letter to us. Hardware items are counted by weight and if a few are missing, please obtain them locally if at all possible.

Read the note on soldering on the inside of the back cover. Crimp all leads tightly to the terminal before soldering. Be sure both the lead and the terminal are clean of wax, corrosion, or other foreign substances. Use only the best rosin core solder, preferably a type containing the new activated fluxes such as Kester "Resin-Five," Ersin "Multicore," or similar types.

NOTE: ALL GUARANTEES ARE VOIDED AND WE WILL NOT REPAIR OR SERVICE INSTRUMENTS IN WHICH ACID CORE SOLDER OR PASTE FLUXES HAVE BEEN USED. WHEN IN DOUBT ABOUT SOLDER, IT IS RECOMMENDED THAT A NEW ROLL PLAINLY MARKED "ROSIN CORE RADIO SOLDER" BE PURCHASED.

Resistors and controls generally have a tolerance rating of $\pm 20\%$ unless otherwise stated in the parts list. Therefore a 100 K Ω resistor may test anywhere from 80 K Ω to 120 K Ω . (The letter K is commonly used to designate a multiplier of 1000.) Tolerances on condensers are generally even greater. Limits of $+100\%$ and -50% are common for electrolytic condensers. The parts furnished with your Heathkit have been specified so as to not adversely affect the operation of the finished instrument.

In order to expedite delivery to you, we are occasionally forced to make minor substitutions of parts. Such substitutions are carefully checked before they are approved and the parts supplied will work satisfactorily. By checking the parts list for resistors, for example, you may find that a 2.2 megohm resistor has been supplied in place of a 2 megohm as shown in the parts list. These changes are self-evident and are mentioned here only to prevent confusion in checking the contents of your kit.

We strongly urge that you follow the wiring and parts layout shown in this manual. The position of wires and parts is quite critical in this instrument and changes may seriously affect the characteristics of the circuit.

STEP-BY-STEP ASSEMBLY

The construction of the Heathkit Impedance Bridge is broken down into four parts: chassis parts mounting and wiring, panel parts mounting and wiring, wiring common to both chassis and panel, and test and calibration. If the step-by-step procedure is followed with the aid of the figures and the pictorials, little difficulty should be encountered in construction. Be sure to read each step all the way through before you start to do it. When the step is completed, check it off in the space provided.

We suggest that you do the following before any work is started:

1. Attach the large fold-in pictorials to the wall above your work bench.
2. Go through the entire assembly and wiring instructions. This is an excellent time to read the entire instructions through and familiarize yourself with the procedure.
3. Lay out all parts so that they are readily available.

MOUNTING OF PARTS ON CHASSIS

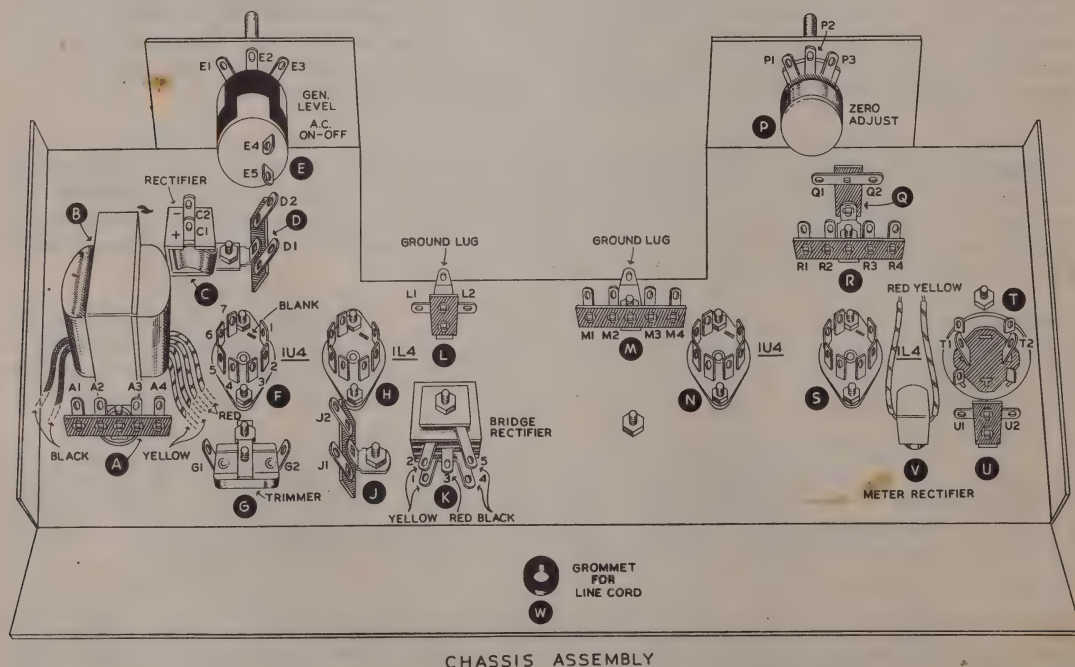


Figure 5

() Install the 3/8 rubber grommet for the line cord through the hole W.

() Using 3-48 x 1/4 screws and nuts (no lockwashers) mount the four 7-pin tube sockets in positions F, H, N and S. Locate the blank spaces as shown in Figure 5 so as to have the sockets in the best position for wiring. See Figure 6.



() Using 6-32 screws, lockwashers and nuts, mount the condenser mounting wafer in position T. Under one of the nuts, in position U, mount a 1-lug terminal strip as shown.

() Mount the meter rectifier in position V, using a lockwasher and nut.

Figure 6

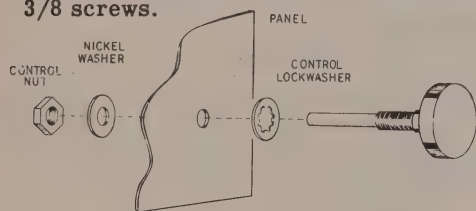
() In positions Q and R, mount a 1-lug and a 4-lug terminal strip using a 6-32 screw, lockwasher and nut.

() In the same manner, mount a 2-lug terminal strip in position J.

() In position D, mount a 2-lug terminal strip. On the same screw, mount the rectifier as shown in Figure 5. Be sure it is in the position indicated.

() Mount the trimmer condenser in position G, using 6-32 screw, lockwasher and nut.

() Mount the power transformer in position B. The black leads should be on the side at the end of the chassis. Under the nut in position A, mount a 4-lug terminal strip using 6-32 x 3/8 screws.



() In position E, mount the 10 K Ω control (generator level control) with the switch on the rear. Use lockwasher and nut as shown in the diagram. Do not tighten this nut as it will be used later for attaching the chassis to the panel. See Figure 7.

HOW TO MOUNT CONTROLS & SWITCHES

Figure 7

() In the same manner, in position P, mount the other 10 K Ω control (zero adjust control). Again do not tighten.

() Mount the 1000-1000 μ fd condenser on the mounting wafer in position T. The manner of mounting is shown in Figure 8. Secure the condenser to the wafer by twisting each of the four mounting lugs about 1/8 turn with the pliers. Hold the condenser firmly against the wafer while twisting the lugs.

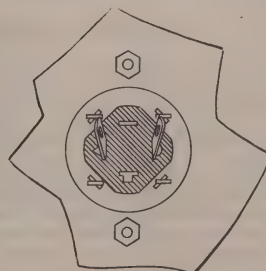


Figure 8

CONDENSER MOUNTING

() Mount the bridge transformer on the top of the chassis as shown in Figure 9. Use the #8 nickel washers under the heads of the screws. Under the nut in position L, mount a 1-lug terminal strip and a ground lug. Under the nut in position M, mount a 4-lug terminal strip and a ground lug. Use 6-32 x 3/8 screws. In position K, use a 6-32 x 1" screw and mount the bridge rectifier under the nut using a lockwasher.

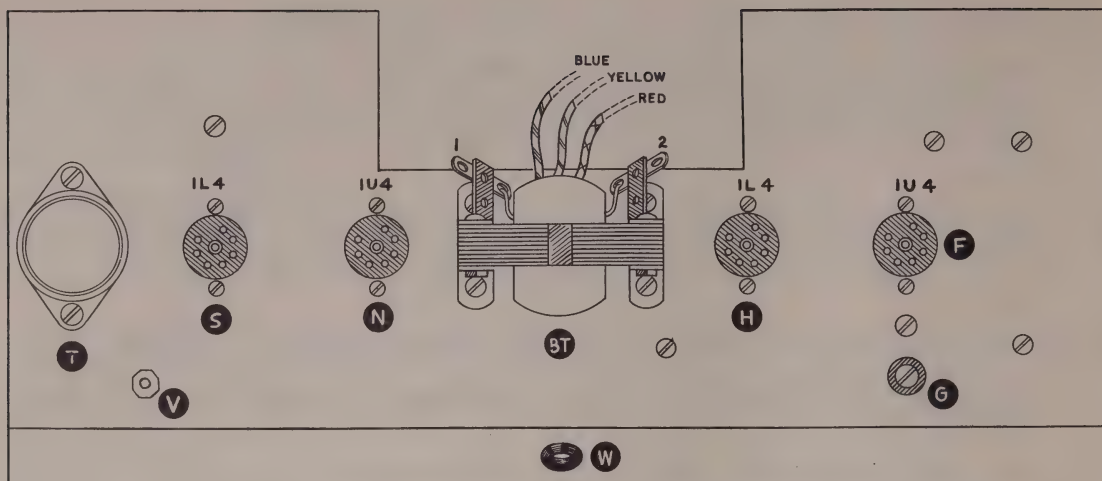


Figure 9

WIRING THE CHASSIS

Read the notes on the inside rear cover concerning wiring and soldering.

The leads on components such as transformers, resistors and condensers are frequently longer than necessary. When wiring these parts into the circuit, the leads should be cut to the proper length. Not only will this result in a neater looking instrument, but in many instances proper operation is impossible with long untrimmed lead wires in critical parts of the circuit.

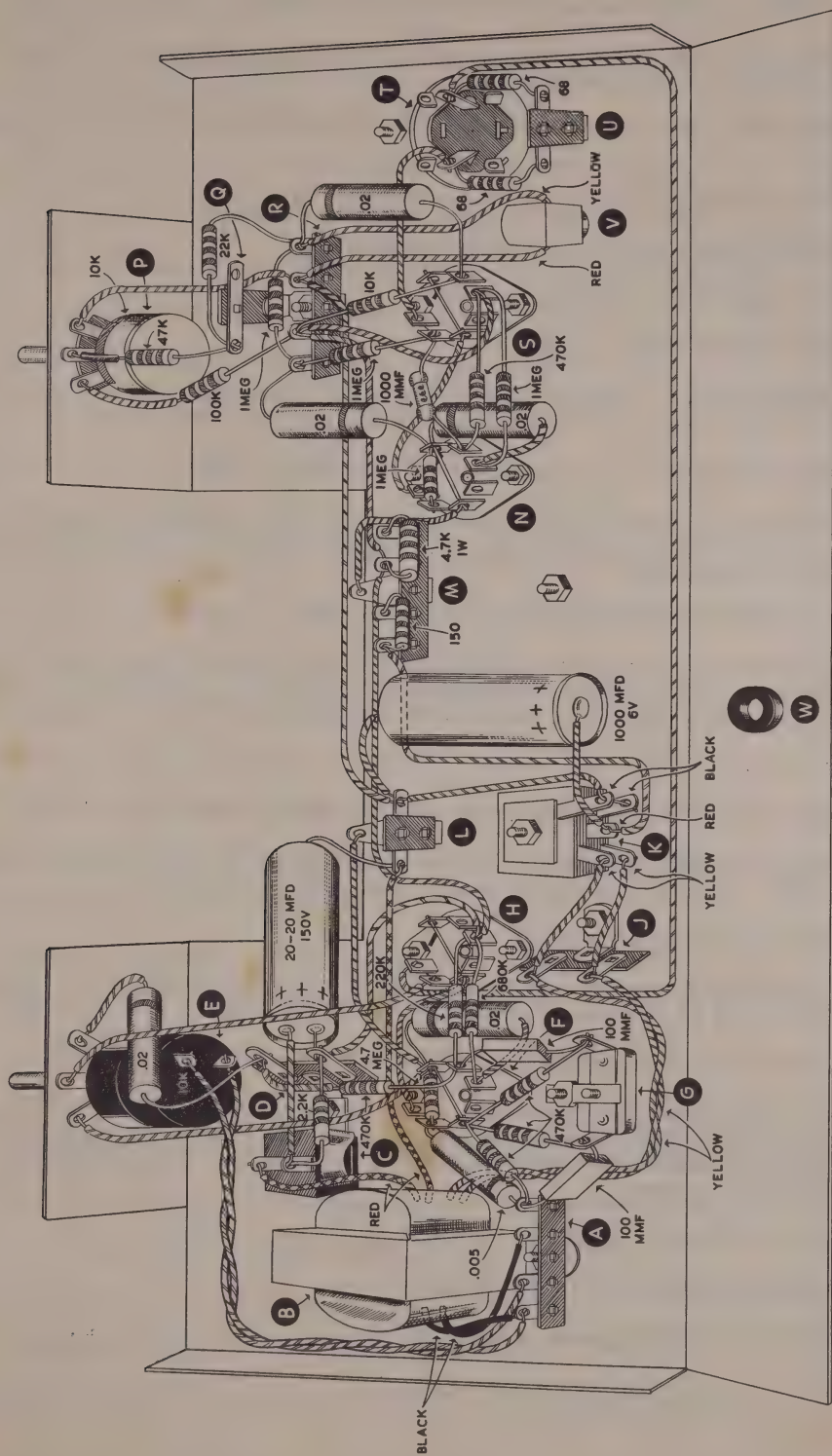
Unless otherwise indicated, all wire used is insulated. Wherever there is a possibility of the bare leads on resistors and condensers shorting to other parts or to chassis, the leads should be covered with insulated sleeving. This is indicated in the instructions by the phrase, "use sleeving."

(S) means solder.

(NS) means do not solder yet.

NOTE: ALL GUARANTEES ARE VOIDED AND WE WILL NOT REPAIR OR SERVICE INSTRUMENTS IN WHICH ACID CORE SOLDER OR PASTE FLUXES HAVE BEEN USED. WHEN IN DOUBT ABOUT SOLDER, IT IS RECOMMENDED THAT A NEW ROLL PLAINLY MARKED "ROSIN CORE RADIO SOLDER" BE PURCHASED.

- () Connect one of the black transformer leads to A1 (NS).
- () Connect the other black lead to A3 (NS).
- () Twist together the two yellow leads of the power transformer. Connect one of them to J1 (NS) and the other one to J2 (NS).
- () Connect one of the red leads of the power transformer to C2 (S). This is the terminal of the rectifier which is NOT marked plus (+). It is important that the proper lug be used, otherwise the instrument will not operate.



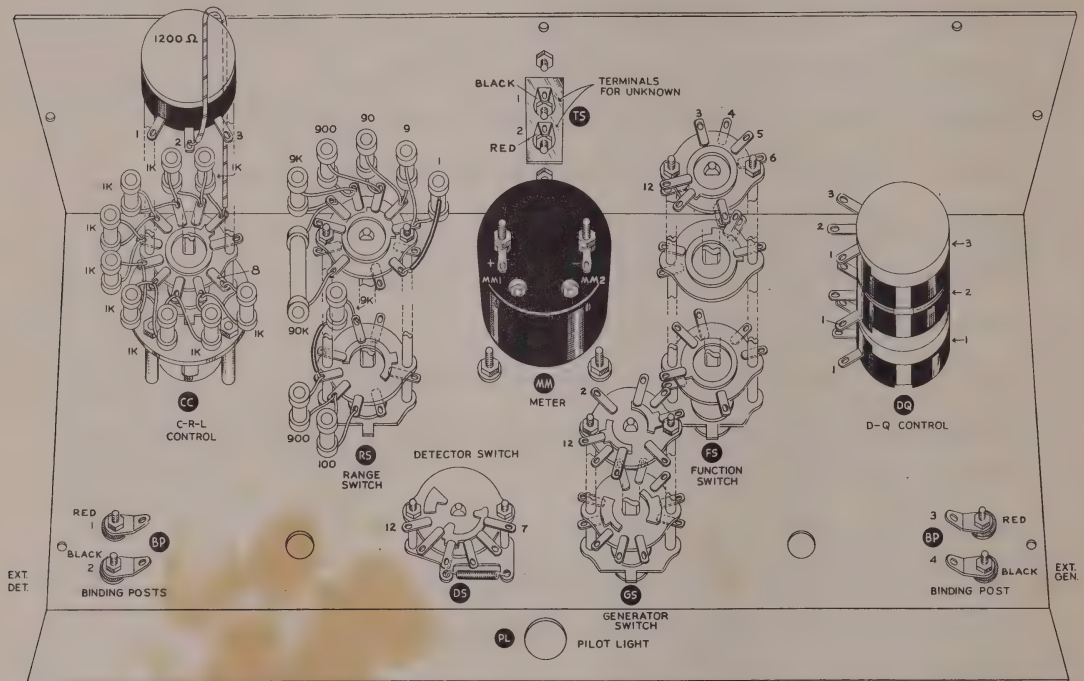
Pictorial 1
Chassis Wiring

- () Connect the other red lead of the power transformer to L1 (NS).
- () Connect a short wire from J1 (NS) to K1 (yellow) on the bridge rectifier (S). It may be convenient to remove the rectifier for this step.
- () Connect another short wire from J2 (NS) to the other yellow lug K2 of the bridge rectifier (S).
- () Connect a wire from H7 (S) to T2 of the filter condenser (NS).
- () Run a short piece of bare wire between H1 (S) and H5 (NS).
- () Connect a wire from H5 (S) to F7 (S).
- () Connect a wire from H3 (NS) to D1 (NS).
- () Strip the insulation from 1" of the end of a piece of wire. Run the wire through F1 (NS) to F5 (NS). Connect the other end of the wire to the ground lug in position L (NS).
- () Connect a wire from E1 (S) on the generator level control to F1 (NS).
- () Connect the outside foil lead of a .02 μ fd condenser to F1 (NS). Connect the other lead of this condenser to F3 (NS). (Use sleeving.) The outside foil lead is on the end of the condenser having the black band.
- () Connect a 4.7 megohm resistor between F1 (S) and F6 (NS).
- () Cut two wires about 8" long and twist them together. Connect one end of the twisted pair to E4 (S) and E5 (S), the connections to the switch on the rear of the generator level control. Connect the other ends of the twisted pair to A1 (S) and A2 (NS).
- () Connect a wire from H3 (NS) to M3 (NS).
- () Connect a wire from the red lug of the bridge rectifier, K3 (NS) to M1 (NS).
- () Using a short piece of bare wire, connect the two black lugs, K4 and K5 of the bridge rectifier together (NS). (This may already be done in the rectifier in your kit.)
- () Connect a wire from K5 (S) to L2 (NS).
- () Connect the positive lead (marked +) of the single section 1000 μ fd condenser to the red lug of the bridge rectifier K3 (S). (Use sleeving.)
- () Connect the other lead of this condenser to L2 (NS).
- () The 20-20 μ fd 150 volt condenser has two leads on the end marked positive (+). Connect one of these leads to D1 (NS). Connect the other lead from the same end to C1 (NS). (Use sleeving.) This is the positive lug on the rectifier and is the one on the side of the rectifier nearer the power transformer.
- () Connect the lead on the other end of this condenser to L1 (NS).
- () Connect a 2.2 K Ω resistor from C1 (S) to D1 (S).
- () Connect one lead of a .02 μ fd condenser to E3 (S). (Use sleeving.) Connect the other lead to D2 (NS).
- () Connect a wire from E2 (S) to H6 (S).

- () Connect one lead of a 470 K Ω resistor to D2 (S). (Use sleeving.) Connect the other lead to F2 (NS).
- () Connect the 220 K Ω resistor from F2 (NS) to H3 (NS).
- () Connect the 680 K Ω resistor from F3 (S) to H3 (S).
- () Connect one of the 100 μ f condensers from F2 (S) to G2 (NS).
- () Connect one of the 470 K Ω resistors between F5 (NS) and G2 (S).
- () Connect another of the 470 K Ω resistors between F5 (NS) and G1 (NS).
- () Connect a 470 K Ω resistor between F5 (S) and A4 (NS).
- () Connect a .005 μ f condenser from F6 (S) to A4 (NS).
- () Connect a 100 μ f condenser between G1 (S) and A4 (S).
- () Connect a wire from L2 (S) to R3 (NS).
- () Connect the red lead of the meter rectifier V to R3 (NS).
- () Connect the yellow lead of the meter rectifier V to lug R4 (NS).
- () Connect a short piece of bare wire between S1 (S) and S5 (NS).
- () Connect a piece of wire from S5 (S) to N7 (S).
- () Connect a wire from S3 (NS) to R2 (NS).
- () Connect a wire from R2 (NS) to M3 (NS).
- () Connect a short piece of bare wire between N1 (NS) and N5 (NS).
- () Connect a piece of wire from N5 (S) to the ground lug at M (NS).
- () Connect a wire from S7 (S) to T1 (NS).
- () Connect a 68 Ω resistor between T1 (S) and U1 (S).
- () Connect a 68 Ω resistor between T2 (S) and U2 (NS).
- () Connect a 22 K Ω resistor between R4 (NS) and Q1 (NS).
- () Connect a wire from P3 (S) to R3 (S).
- () Connect one lead of a 47 K Ω resistor between P2 (S) (use sleeving) and Q1 (NS).
- () Connect one lead of a 100 K Ω resistor from P1 (S) (use sleeving) to R2 (NS).
- () Connect a .02 μ f condenser between R4 (NS) and S2 (NS).
- () Connect a 10 K Ω resistor between R2 (S) and S2 (S).
- () Connect a 1 megohm resistor between R4 (S) and R1 (NS).
- () Connect a 1 megohm resistor between R1 (NS) and S6 (NS).

- () Connect a 1 megohm resistor between N6 (NS) and N1 (NS).
- () Connect the outside foil lead of a .02 μ fd condenser to N1 (NS) and the other lead of this condenser to R1 (S).
- () Connect a .02 μ fd condenser between N1 (S) and N3 (NS).
- () Connect a 1000 μ mf condenser between S6 (S) and N2 (NS).
- () Connect a 470 K Ω resistor between N2 (S) and S3 (NS).
- () Connect a 1 megohm resistor between N3 (S) and S3 (S).
- () Connect a 150 Ω resistor between M1 (NS) and M2 (NS).
- () Connect a 4700 Ω 1 watt resistor between M3 (NS) and M4 (NS).

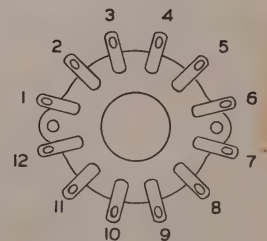
MOUNTING OF PARTS ON PANEL



PANEL ASSEMBLY

Figure 10

Before mounting the parts on the panel, the switch on the CRL control, #19-17 should have the resistors mounted. The resistors should also be mounted on the range switch, #63-62. It is important that the switch be in the proper position before soldering the resistors in place. Refer to Figure 10 and to Figure 11 showing the numbering of the contacts on the switch.



SWITCH NUMBERING

As seen from rear when mounted
as in Figure 10

Figure 11

WIRING OF CRL SWITCH

- () There are nine 1 K Ω precision resistors. Connect one lead of a 1 K Ω resistor to lug 8 of the switch on the CRL control, #19-17 (S).
- () Connect the other lead to lug 9 of the switch (NS).
- () Connect a 1 K Ω resistor between lug 9 (S) and lug 10 (NS).
- () Connect a 1 K Ω resistor between lug 10 (S) and lug 11 (NS).
- () Connect a 1 K Ω resistor between lug 11 (S) and lug 12 (NS).
- () Connect a 1 K Ω resistor between lug 12 (S) and lug 1 (NS).
- () Connect a 1 K Ω resistor between lug 1 (S) and lug 2 (NS).
- () Connect a 1 K Ω resistor between lug 2 (S) and lug 3 (NS).
- () Connect a 1 K Ω resistor between lug 3 (S) and lug 4 (NS).
- () Connect a 1 K Ω resistor between lug 4 (S) and lug 5 (NS).
- () Connect a wire between lug 5 of the switch (S) and the center lug of the 1200 Ω control on the rear of the switch (S). See Figure 10.

This completes the preliminary wiring of the CRL switch.

WIRING OF RESISTORS ON RANGE SWITCH

- () Connect one lead of a 9 K Ω precision resistor to R1R3 (S). (Be sure the switch is in the proper position.) R1R3 means range switch, first deck (counting from panel out), rear of deck, contact #3.
- () Connect the other lead to R1R12 (NS). (Use sleeving.)
- () Connect a 900 Ω precision resistor between R1R12 (S) and R1R11 (NS).
- () Connect one lead of a 100 Ω precision resistor to R1R11 (S).
- () Connect the other lead to R1R10 (NS).
- () Connect a 1 Ω precision resistor between R2R8 (NS) (use sleeving) and R2R6 (NS).
- () Connect a 9 Ω precision resistor between R2R6 (S) and R2R5 (NS).
- () Connect a 90 Ω precision resistor between R2R5 (S) and R2R4 (NS).
- () Connect a 900 Ω precision resistor between R2R4 (S) and R2R3 (NS).
- () Connect a 9 K Ω precision resistor between R2R3 (S) and R2R2 (NS).
- () Connect a 90 K Ω precision resistor between R2R2 (S) and R2R11 (S).

This completes the preliminary wiring of the range switch.

- () Mount the binding posts on the terminal board insulator as shown in Figure 12.
- () Using 6-32 screws, lockwashers and nuts, mount the terminal board insulator on the top of the panel in position TS.

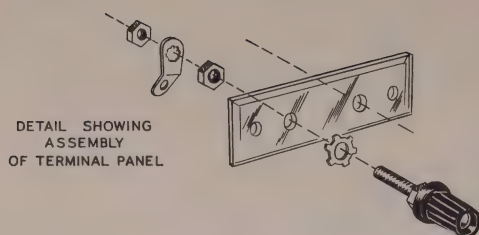


Figure 12

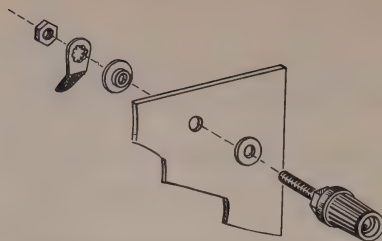


Figure 13

- () Referring to Figure 13, mount the binding posts in positions BP-1, 2, 3, 4.
- () Using 6-32 x 1" screws and 3/4" spacers, mount the CRL mounting bracket on the panel in position CC.
- () Mount the CRL control on the CRL mounting bracket.
- () Mount the range switch, #63-62, in position RS.
- () Mount the function switch, #63-63, in position FS.
- () Mount the DQ control in position DC. This is the 3-gang control.
- () Mount the generator switch, #63-61, in position GS.
- () Mount the detector switch, #63-60, in position DS.
- () Mount the 100-0-100 microampere meter in position MM using the washers and nuts provided with the meter. Use the #8 solder lugs on the meter terminals.

WIRING OF THE PANEL

The accuracy of the bridge is dependent on the wiring. Heavy bus wire is provided for wiring the switches. The resistance of the wiring is held to a minimum by the large bus wire. The capacity of the wiring is held to a minimum by using an open, rigid style of wiring as shown in the pictorial. Notice carefully the proper positions of the switches on the panel. Also the proper numbering of the contacts on the switches. The switches are shown in the schematic in the same positions as they appear on the panel. Check with this as well as with the pictorial. Make a good mechanical joint of each connection. The solder is not a good conductor and serves only to hold the connection rigid. Poor connections will impair the accuracy of the bridge.

Before wiring the panel, place one end of the bus wire in a vise and pull the other end with a pair of pliers. Pull until the wire stretches. This will remove any kinks and will stiffen the wire resulting in a better and neater job of wiring.

Proceed carefully, as once the switches are wired, it is very difficult to change the connections to correct an error.

- () Run a piece of bus (heavy solid wire) from C6 (S) through F1R6 (NS) to F2R6 (NS). Now solder F1R6.
- () Connect F1F5 (S) to R1R1 (S) and R2R1 (NS). Use bus.
- () Connect F1F3 (S) to TS2 (S). Use bus.

- () Connect F1R2 (S) to TS1 (S). Use bus.
- () Run one end of a piece of bus wire through F2F4 (NS) to F2R4 (S). Now solder F2F4.
- () Connect the other end to R2R8 (S).
- () Run a piece of bus wire through F3R12, F3F12, F2F12, F1R12 to F1F12. Now solder all but F3R12.
- () Run a bus wire from F2R1 (S) to R1R10 (S).
- () Using insulated hookup wire, connect R1F7 (S) to G1R4 (S).
- () Again using insulated wire, connect R2F9 (S) to G2R12 (S).
- () Run a bus wire from R2R1 (S) to D7 (S).
- () Using insulated wire, connect MM2 (S) (negative terminal of the meter) to D11 (S).
- () Connect a bus wire from F2R6 (S) to G2R4 (S).
- () Run a bus wire from CRL3 (S) through MM1 (NS) to F1R9 (NS). Now solder MM1.
- () Connect one lead of a .1 μ f precision condenser to F1R9 (S). (Use sleeving.)
- () Connect the other lead to F3R5 (NS). (Use sleeving.)
- () Run a bus wire from F3R5 (S) to lug 2 of DQ1 (S).
- () Run a bus wire from F3R3 (S) to lug 3 of DQ1 (S).
- () Run a bus wire from F3F6 (NS) through lug 2 of DQ3 (NS) to lug 2 of DQ2 (S). Now solder DQ3.
- () Run a bus wire from F3F9 (S) through F3R9 (S) to lug 1 of DQ3 (S).
- () Run a bus wire from F3R11 (S) to lug 1 on DQ2 (S).
- () Run a bus wire from F3R12 (S) to G2R10 (S).
- () Connect one lead of a .01 μ f precision condenser to F3F6 (S). (Use sleeving.)
- () Connect the other lead to F3F4 (NS). (Use sleeving.)
- () Run a bus wire from F3F4 (S) to MM1 (S). The connection to MM1 is best made by wrapping the wire from F3F4 around the wire from MM1 near the solder lug.
- () The panel is now mounted on the chassis by removing the nuts on the two controls mounted on the chassis. The panel is put in place and the nickel washers and nuts put on the controls. It may be necessary to omit the lockwashers on these two controls because of the extra thickness of the panel and chassis.

WIRING COMMON TO PANEL AND CHASSIS

NOTE: Use insulated hook-up wire unless otherwise specified. Numbers refer to Pictorial 3.

- ⑨ () Connect the yellow lead of the bridge coupling transformer to R1F4 (S).
- ④ () Connect the red lead of the transformer to R1F9 (S).
- ⑧ () Connect a wire from R2F7 (S) to M4 (S).
- ⑦ () Connect a wire from R2F12 (S) to M2 (S).
- ② () Connect a wire from D9 (S) to BP1 (S).
- ① () Connect a wire from BP2 (S) to the nearest ground lug (S) on condenser mounting wafer T.
- ②⑩ () Connect a short piece of bus wire from the ground lug at M(NS) to the bus wire on the positive terminal of the meter M1 (S). The last connection is made by looping the end of the short wire securely around the wire from the meter so as to make a good mechanical connection.
- ⑤ () Connect a 2.2 Ω resistor between D10 (S) and the ground lug at M (S).
- ⑥ () Connect a 1000 $\mu\mu\text{f}$ condenser from N6 (S) (use sleeving) to D8 (S).
- ③ () Connect a wire from Q1 (S) to D12 (S).
- ⑪ () Connect the blue lead of the bridge transformer to G1R10 (S).
- () Strip 1" of insulation from one end of a piece of wire. Pass this through G1R5 (NS) to G2R5 (S). Now solder G1R5.
- ①⑨ () Connect the other end of the wire to BP3 (S).
- () Again strip 1" of the insulation from a piece of wire. Pass it through G2R6 (NS) to G1F6 (S). Now solder G2R6.
- ⑱ () Connect the other end to L1 (S).
- ⑭ () Connect a wire from G1R3 (S) to M3 (S).
- ⑳ () Run a piece of bus wire from G2R2 (S) to BT1 (S).
- ⑬ () Run a wire from G1F1 (S) to U2 (S).
- ⑫ () Run a wire from G1F12 (S) to M1 (S).
- () Strip 1" of insulation from one end of a piece of wire. Pass this through G1R11 (NS) to G2R11 (S). Now solder G1R11.
- ⑮ () Connect the other end to BP4 (S).
- ㉒ () Run a piece of bus wire from G2R8 (S) to BT2 (S).
- ⑰ ~~()~~ Connect a wire from G1F7 (S) to the ground lug at L (S).
- ⑯ () Connect a wire from G1R9 (S) to H2 (S).
- () Mount the pilot light in position PL. Refer to Figure 14.

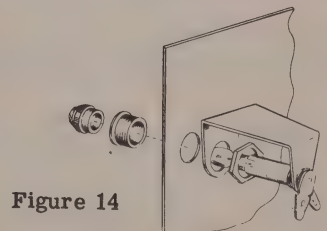


Figure 14

PILOT LIGHT ASSEMBLY

- ⑩ () Twist two wires together and run them from PL1 (S) and PL2 (S) to J1 (S) and J2 (S).
- () Run the line cord through the rubber grommet W in the rear of the chassis and tie a knot inside the chassis to keep the cord from being pulled out. Allow sufficient length inside the chassis for the cord to reach terminal strip A.
- () Connect one lead to A2 (S) and the other lead to A3 (S).
- () Install the knobs, making sure that the pointer positions check with the panel markings. Use 8-32 set screws for holding the knobs.
- () Install the DQ control knob.
- () Install the CRL control ring and knob.
- () Using #6 self tapping screws, mount the two stationary pointers for the DQ and CRL controls.
- () Adjust the ring of the CRL control so the numbers line up with the stationary pointer. The knob will be adjusted later.
- () Install the rubber feet in the bottom of the cabinet as shown in Figure 15.
- () Install the 1L4 and 1U4 tubes in their proper sockets. See Figure 9.



Figure 15

IMPORTANT WARNING

MINIATURE TUBES CAN BE EASILY DAMAGED WHEN PLUGGING THEM INTO THEIR SOCKETS. THEREFORE, USE EXTREME CARE WHEN INSTALLING THEM. WE DO NOT GUARANTEE OR REPLACE MINIATURE TUBES BROKEN DURING INSTALLATION.

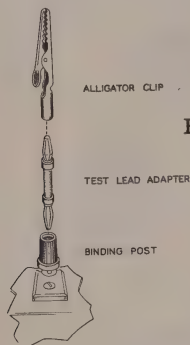


Figure 16

- () Two alligator clips and adapters with banana plugs are provided as test leads. These plug into the terminals of the bridge as shown in Figure 16. The unknown may then be clipped between them.
- () After making the initial adjustments, install the instrument in the cabinet and fasten with two #6 self tapping screws through the rear into the chassis, and with seven #6 screws through the panel into the cabinet.

INITIAL ADJUSTMENTS

Plug the line cord into a 105-125 volt 50/60 cycle AC outlet only. **SERIOUS DAMAGE TO THE TRANSFORMER WILL RESULT IF PLUGGED INTO A DC SUPPLY.** Turn on the power switch on the **GENERATOR LEVEL** control.

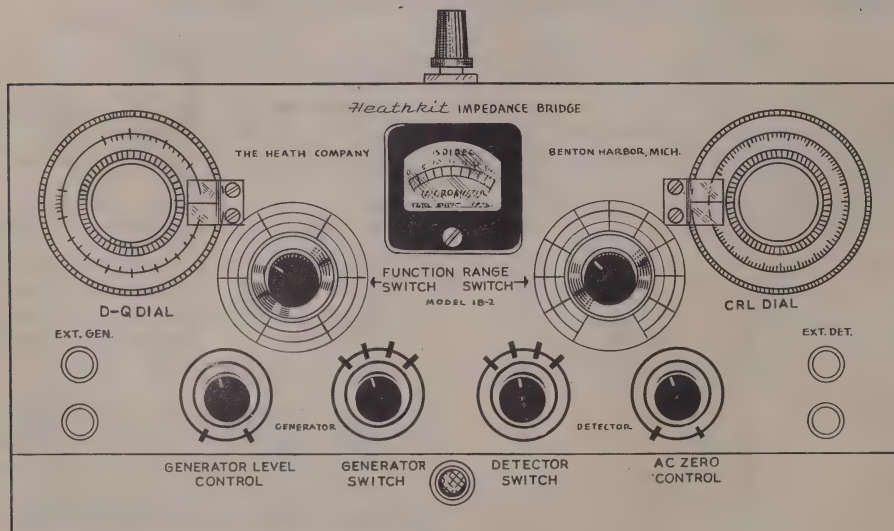
The oscillator circuit is designed to operate somewhere between 800 and 1200 cps. The actual frequency will depend on the components. A trimmer condenser is provided so that the frequency may be set at approximately 1 kc by use of an audio generator. The most convenient method is to use an oscilloscope. Set the audio generator at 1 kc and connect it to one set of plates of the oscilloscope. Connect the terminals on top of the bridge to the other set of plates of the os-

cilloscope. Set the GENERATOR switch at AC INTERNAL, the DETECTOR switch at AC INTERNAL, the GENERATOR LEVEL control clockwise, the FUNCTION switch at L-DQ and the RANGE switch at 1h. Adjust the trimmer until a circle or ellipse appears on the oscilloscope. The bridge generator frequency is then equal to the frequency of the audio generator.

If an oscilloscope is not available, headphones may be used. The output of the audio generator and the bridge oscillator may be fed into the earphones and the trimmer adjusted until zero beat is heard. The frequency of the bridge oscillator will then equal the frequency of the audio oscillator. The bridge may still be used even if an audio oscillator is not available. Tighten the trimmer condenser by turning the screw clockwise. Then turn the screw 1/2 turn counter-clockwise. This will set the oscillator at approximately 1 kc. Later adjustment may be made when additional equipment is available.

The CRL control is set as follows. Check the zero setting of the galvanometer. Set the FUNCTION switch to R. Set the GENERATOR switch to DC INTERNAL and the DETECTOR switch to DC SHUNT. Set the RANGE switch to 100 Ω on the R scale. Set the ring of the CRL control to 5. Connect the 550 Ω precision resistor supplied for calibration across the terminals on the top of the bridge. Rotate the knob of the CRL control until the galvanometer does not move when the DETECTOR switch is moved to DC METER position. The switch is spring loaded in this position so it will return to DC SHUNT position when released. Now loosen the CRL control knob and rotate it until it reads .5 on the stationary pointer. The CRL dial now will read 5.5. Tighten the CRL control knob and again check to see that the meter does not move when the DETECTOR switch is moved to DC METER position. Repeat the adjustment until the meter does not move. The CRL control is now set and ready for use.

OPERATION



FRONT PANEL SHOWING CONTROLS

Figure 17

DC Resistance Measurements

1. Plug in the cord and turn on the switch mounted on the GENERATOR LEVEL control.
2. Check the zero setting of the galvanometer.
3. Connect the unknown resistance to the terminals on top of the bridge.
4. Set the FUNCTION switch to R.
5. Set the GENERATOR switch to DC INTERNAL.
6. Set the DETECTOR switch to DC SHUNT.
7. Set the CRL DIAL to zero.

8. Set the RANGE switch (CRL multiplier dial) to the setting that results in minimum deflection of the galvanometer. Choose the setting that gives a reading to the left of the zero mark.
9. Turn the rim of the CRL control for approximate balance, then continue with the center knob for further balance.
10. For final balance, turn the DETECTOR switch to DC METER.
11. Multiply CRL reading by multiplier setting of the RANGE switch to find the resistance. For resistance measurements below 1 Ω , it is recommended that an external galvanometer of greater sensitivity be used.

Low resistance measurements are subject to errors due to the internal resistance of the bridge and resistances of the contacts and leads. The internal resistance of the bridge can be measured by shorting the unknown terminals with a piece of heavy wire and balancing the bridge in the usual manner. It will probably be of the order of .02 Ω . The lead resistance can be partially eliminated by connecting the resistance directly to the binding post. Cleaning the leads will also help to minimize errors in lead resistance. When measuring low resistances, the internal resistance of the bridge should be subtracted from the measured value of resistance to give the corrected value.

Inductance Measurements at 1000 Cycles

1. Connect the unknown inductor to the terminals on top of the bridge.
2. Set the GENERATOR switch to AC INTERNAL.
3. Set the DETECTOR switch to AC INTERNAL.
4. Set the FUNCTION switch to L-DQ.
5. Set the AC ZERO control so that the meter reads 100 microamperes counterclockwise. The GENERATOR LEVEL control should be in counterclockwise while this is done.
6. Set the GENERATOR LEVEL control so that the meter will move about half scale.
7. Set the RANGE switch so that the meter will read maximum counterclockwise.
8. Alternately adjust the CRL and DQ dials until the meter reads maximum counterclockwise. Move the GENERATOR LEVEL control clockwise as balance is approached so that at final balance it will be in maximum clockwise position. If the DQ setting tends to go above 10, set the FUNCTION switch to L-Q and again balance as above.
9. Multiply the CRL reading by the multiplier setting of the RANGE switch to find L. Q is read directly from the DQ or Q scale.

Inductance measurements at other frequencies may be made by using an external generator. Set the GENERATOR switch to EXTERNAL GENERATOR and measure as outlined for 1000 cycles.

Capacitance Measurements at 1000 cycles

1. Connect the unknown capacitance to the terminals on top of the bridge.
2. Set the GENERATOR switch to AC INTERNAL.
3. Set the DETECTOR switch to AC INTERNAL.
4. Set the FUNCTION switch to C-DQ.
5. Set the AC ZERO control so that the meter reads 100 microamperes counterclockwise. The GENERATOR LEVEL control should be in counterclockwise position while this is done.
6. Set the GENERATOR LEVEL control so the meter will read about half scale.
7. Set the RANGE switch so that the meter will read maximum counterclockwise.
8. Adjust the CRL and DQ dials until the meter reads maximum counterclockwise. The GENERATOR LEVEL control should be moved clockwise as balance is approached so that at final balance it is in maximum clockwise position. If the DQ setting tends to go below one, set the FUNCTION switch to CD and again balance as above.
9. Multiply the CRL reading by the multiplier setting on the RANGE switch to find C. Read D directly on the DQ dial.

Capacitance measurements at frequencies other than 1000 cycles may be made by using an external generator and following the method outlined above.

The CRL reading is independent of frequency. Dissipation factor and storage factor both depend upon frequency, however, so a correction factor must be applied to the D-Q readings. For 1 kc, the D and Q readings are direct. For frequencies other than 1 kc, the dissipation factor D is obtained by multiplying the observed value of D by the frequency in kilocycles. Storage factor Q at any frequency is the observed value on the DQ dial multiplied by the frequency in kilocycles or the observed value on the Q dial divided by the frequency in kilocycles.

IN CASE OF DIFFICULTY

1. Check the wiring by following each wire on the pictorial and in the instrument, inspecting the soldered connections on each end and then checking off that wire on the pictorial with a colored pencil. This will reveal mistakes and omissions in wiring, which is the most frequent cause of difficulties. Often having a friend check the wiring will reveal a mistake consistently overlooked.
2. Check the position of the switches on the panel and be sure they are in the proper position.
3. Check the tubes.
4. Check the voltages between tube socket terminals and chassis. The readings should come reasonably close to the values tabulated below, if a vacuum tube voltmeter with 11 megohm input resistance is used. Other type meters may give considerably lower readings. If a voltage reading fails to check with the tabulation, investigate the portion of the circuit involved by checking the resistors and condensers.

VOLTAGE CHART

SOCKET	TUBE	Pin 1	Pin 2	Pin 3	Pin 4	Pin 5	Pin 6	Pin 7
GENERATOR F	1U4	0	50-55	45-50	NC	0	.3-.35*	1.4-1.45
H	1L4	1.4-1.45	95-105	100-110	NC	1.4-1.45	NS	2.4-2.6
DETECTOR N	1U4	0	40-45	35-40	NC	0	.3-.35*	1.4-1.45
S	1L4	1.4-1.45	70-75	100-110	NC	1.4-1.45	22-23*	2.4-2.6

* - Negative with respect to chassis.

NC - No connection.

NS - Not significant.

All measurements made with GENERATOR LEVEL control set at maximum, GENERATOR switch at AC INTERNAL, DETECTOR switch at AC INTERNAL, FUNCTION and RANGE switches in maximum clockwise position.

Unless otherwise indicated, all voltages are positive and measured to chassis.

Line voltage - 115 volts, 60 cycles.

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- Terman, F.E., "Radio Engineers' Handbook," section 13, McGraw-Hill Book Co., New York
- Stout, M.B., "Basic Electrical Measurements," ch. 9, 13, Prentice-Hall, Inc., New York
- Harris, F.K., "Electrical Measurements," ch. 7, 15, John Wiley, and Sons, New York

REPLACEMENTS

Material supplied with Heathkits has been carefully selected to meet design requirements and ordinarily will fulfill its function without difficulty. Occasionally improper instrument operation can be traced to a faulty tube or component. Should inspection reveal the necessity for replacement, write to the Heath Company and supply all of the following information:

- A. Thoroughly identify the part in question by using the part number and description found in the manual parts list.
- B. Identify the type and model number of kit in which it is used.
- C. Mention the order number and date of purchase.
- D. Describe the nature of defect or reason for requesting replacement.

The Heath Company will promptly supply the necessary replacement. Please do not return the original component until specifically requested to do so. Do not dismantle the component in question as this will void the guarantee. If tubes are to be returned, pack them carefully to prevent breakage in shipment as broken tubes are not eligible for replacement. This replacement policy does not cover the free replacement of parts that may have been broken or damaged through carelessness on the part of the kit builder.

SERVICE

In event continued operational difficulties of the completed instrument are experienced, the facilities of the Heath Company Service Department are at your disposal. Your instrument may be returned for inspection and repair for a service charge of \$5.00 plus the cost of any additional material that may be required. **THIS SERVICE POLICY APPLIES ONLY TO COMPLETED INSTRUMENTS CONSTRUCTED IN ACCORDANCE WITH THE INSTRUCTIONS AS STATED IN THE MANUAL.** Instruments that are not entirely completed or instruments that are modified in design will not be accepted for repair. Instruments showing evidence of acid core solder or paste fluxes will be returned NOT repaired.

The Heath Company is willing to offer its full cooperation to assist you in obtaining the proper operation of your instrument and therefore this factory repair service is available for a period of one year from the date of purchase.

SHIPPING INSTRUCTIONS

Before returning a unit for service, be sure that all parts are securely mounted. Attach a tag to the instrument giving name, address and trouble experienced. Pack in a rugged container, preferably wood, using at least three inches of shredded newspaper or excelsior on all sides. **DO NOT SHIP IN THE ORIGINAL KIT CARTON AS THIS CARTON IS NOT CONSIDERED ADEQUATE FOR SAFE SHIPMENT OF THE COMPLETED INSTRUMENT.** Ship by prepaid express if possible. Return shipment will be made by express collect. Note that a carrier cannot be held liable for damage in transit if packing, in **HIS OPINION**, is insufficient.

SPECIFICATIONS

All prices are subject to change without notice. The Heath Company reserves the right to discontinue instruments and to change specifications at any time without incurring any obligation to incorporate new features in instruments previously sold.

WARRANTY

The Heath Company limits its warranty of parts supplied with any kit to a period of three (3) months from the date of purchase. Replacement will be made only when said part is returned postpaid, with prior permission and in the judgment of the Heath Company was defective at the time of sale. This warranty does not extend to any Heathkits which have been subjected to misuse, neglect, accident and improper installation or applications. Material supplied with a kit shall not be considered as defective, even though not in exact accordance with specifications, if it substantially fulfills performance requirements. This warranty is not transferable and applies only to the original purchaser. This warranty is in lieu of all other warranties and the Heath Company neither assumes nor authorizes any other person to assume for them any other liability in connection with the sale of Heathkits.

The assembler is urged to follow the instructions exactly as provided. The Heath Company assumes no responsibility or liability for any damages or injuries sustained in the assembly of the device or in the operation of the completed instrument.

HEATH COMPANY
Benton Harbor, Michigan

PARTS LIST

PART No.	PARTS Per Kit	DESCRIPTION
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Composition Resistors

1-72	1	2.2 Ω 1/2 watt
1-2	2	68 Ω 1/2 watt
1-66	1	150 Ω 1/2 watt
1-44	1	2.2 K Ω 1/2 watt
1-20	1	10 K Ω 1/2 watt
1-22	1	22 K Ω 1/2 watt
1-25	1	47 K Ω 1/2 watt
1-26	1	100 K Ω 1/2 watt
1-29	1	220 K Ω 1/2 watt
1-33	5	470 K Ω 1/2 watt
1-34	1	680 K Ω 1/2 watt
1-35	4	1 megohm 1/2 watt
1-71	1	4.7 megohm 1/2 watt
1-24A	1	4700 Ω 1 watt

Precision Resistors

2-1	1	1 Ω 1/2%
2-2	1	9 Ω 1/2%
2-3	1	90 Ω 1/2%
2-4	1	100 Ω 1/2%
2-59	1	550 Ω 1/2%
2-5	2	900 Ω 1/2%
2-6	9	1 K Ω 1/2%
2-7	2	9 K Ω 1/2%
2-10	1	90 K Ω 1/2%

Condensers

31-9	1	300-450 μ f trimmer
20-11	2	100 μ f
21-14	2	.001 μ f
23-2	1	.005 μ f
20-27	1	.01 μ f precision mica
23-8	5	.02 μ f
20-28	1	.1 μ f precision mica
25-7	1	20-20 μ f 150 v
25-25	1	1000 μ f 6 v
25-26	1	1000-1000 μ f 6 v

Controls-Switches

10-8	1	10 K Ω control
63-60	1	4-pos. detector switch
63-61	1	4-pos. 2 sec. gen. switch
63-62	1	8-pos. 2 sec. range switch
63-63	1	5-pos. 3 sec. function switch
13-2	1	165-1600-16 K Ω control
19-17	1	1200 Ω control w/10-pos. switch
19-2	1	10 K Ω control w/switch

PART No.	PARTS Per Kit	DESCRIPTION
-------------	------------------	-------------

Meters-Tubes-Lamps

407-4	1	100-0-100 microampere meter
411-56	2	1U4 tube
411-57	2	1L4 tube
412-1	1	#47 pilot lamp

Transformers-Rectifiers

51-16	1	Bridge transformer
54-2	1	Power transformer
57-13	1	35 ma 130 v rectifier
57-6	1	Meter rectifier
57-12	1	Bridge rectifier

Sockets-Terminal Strips-Knobs

434-15	4	7-pin miniature socket
434-22	1	Pilot light socket
75-6	1	Terminal board insulator
431-1	3	1-lug terminal strip
431-2	2	2-lug terminal strip
431-5	3	4-lug terminal strip
462-19	6	Indicator knob
462-20	1	DQ knob
462-21	1	CRL knob
462-22	1	CRL ring
463-5	2	Stationary pointer

Hardware

250-2	8	3-48 x 1/4 machine screw
250-8	13	#6 x 3/8 sheet metal screw
250-9	13	6-32 x 3/8 machine screw
250-13	4	6-32 x 1" machine screw
250-43	9	Set screw
252-1	8	3-48 nut
252-3	26	6-32 nut
252-7	8	Control nut
252-12	1	Pilot light nut
253-1	4	#6 flat fiber washer
253-2	4	#6 fiber shoulder washer
253-9	4	#8 washer
253-10	7	Control nickel washer
254-1	16	#6 lockwasher
254-6	2	#6 external lockwasher
254-4	8	Control lockwasher
255-5	3	#6 x 3/4 spacer
259-1	8	#6 solder lug
259-2	2	#8 solder lug
260-1	2	Alligator clip

<u>PART</u> <u>No.</u>	<u>PARTS</u> <u>Per Kit</u>	<u>DESCRIPTION</u>
Sheet Metal Parts		
200-M53	1	Chassis
203-M54F61	1	Panel
204-M52	1	CRL mounting bracket
90-18	1	Cabinet
Wire		
340-3	1	roll #16 bus wire
344-1	1	roll Hookup wire
346-1	1	length Spaghetti
89-1	1	Line cord

<u>PART</u> <u>No.</u>	<u>PARTS</u> <u>Per Kit</u>	<u>DESCRIPTION</u>
Miscellaneous		
73-1	1	3/8 rubber grommet
100-M16B	3	Binding post cap, black
100-M16R	3	Binding post cap, red
100-M34	2	Test lead assembly
261-1	4	Rubber feet
413-1	1	Pilot light jewel
427-2	6	Binding post base
455-1	1	Pilot light bushing
481-1	1	Condenser mounting wafer
595-71	1	Manual

Notes

HELPFUL KIT BUILDING INFORMATION

Before attempting actual kit construction read the construction manual thoroughly to familiarize yourself with the general procedure. Note the relative location of pictorials and pictorial inserts in respect to the progress of the assembly procedure outlined.

This information is offered primarily for the convenience of novice kit builders and will be of definite assistance to those lacking thorough knowledge of good construction practices. Even the advanced electronics enthusiast may benefit by a brief review of this material before proceeding with kit construction. In the majority of cases, failure to observe basic instruction fundamentals is responsible for inability to obtain desired level of performance.

RECOMMENDED TOOLS

The successful construction of Heathkits does not require the use of specialized equipment and only basic tools are required. A good quality electric soldering iron is essential. The preferred size would be a 100 watt iron with a small tip. The use of long nose pliers and diagonal or side cutting pliers is recommended. A small screw driver will prove adequate and several additional assorted screw drivers will be helpful. Be sure to obtain a good supply of rosin core type radio solder. Never use separate fluxes, paste or acid solder in electronic work.

ASSEMBLY

In the actual mechanical assembly of components to the chassis and panel, it is important that the procedure shown in the manual be carefully followed. Make sure that tube sockets are properly mounted in respect to keyway or pin numbering location. The same applies to transformer mountings so that the correct transformer color coded wires will be available at the proper chassis opening.

Make it a standard practice to use lock washers under all 6-32 and 8-32 nuts. The only exception being in the use of solder lugs—the necessary locking feature is already incorporated in the design of the solder lugs. A control lock washer should always be used between the control and the chassis to prevent undesirable rotation in the panel. To improve instrument appearance and to prevent possible panel marring use a control flat nickel washer under each control nut.

When installing binding posts that require the use of fiber insulating washers, it is good practice to slip the shoulder washer over the binding post mounting stud before installing the mounting stud in the panel hole provided. Next, install a flat fiber washer and a solder lug under the mounting nut. Be sure that the shoulder washer is properly centered in the panel to prevent possible shorting of the binding post.

WIRING

When following wiring procedure make the leads as short and direct as possible. In filament wiring requiring the use of a twisted pair of wires allow sufficient slack in the wiring that will permit the twisted pair to be pushed against the chassis as closely as possible thereby affording relative isolation from adjacent parts and wiring.

When removing insulation from the end of hookup wire, it is seldom necessary to expose more than a quarter inch of the wire. Excessive insulation removal may cause a short circuit condition in respect to nearby wiring or terminals. In some instances, transformer leads of solid copper will have a brown baked enamel coating. After the transformer leads have been trimmed to a suitable length, it is necessary to scrape the enamel coating in order to expose the bright copper wire before making a terminal or soldered connection.

In mounting parts such as resistors or condensers, trim off all excess lead lengths so that the parts may be installed in a direct point-to-point manner. When necessary use spaghetti or insulated sleeving over exposed wires that might short to nearby wiring.

It is urgently recommended that the wiring dress and parts layout as shown in the construction manual be faithfully followed. In every instance, the desirability of this arrangement was carefully determined through the construction of a series of laboratory models.

SOLDERING

Much of the performance of the kit instrument, particularly in respect to accuracy and stability, depends upon the degree of workmanship used in making soldered connections. Proper soldered connections are not at all difficult to make but it would be advisable to observe a few precautions. First of all before a connection is to be soldered, the connection itself should be clean and mechanically strong. Do not depend on solder alone to hold a connection together. The tip of the soldering iron should be bright, clean and free of excess solder. Use enough heat to thoroughly flow the solder smoothly into the joint. Avoid excessive use of solder and do not allow a flux flooding condition to occur which could conceivably cause a leakage path between adjacent terminals on switch assemblies and tube sockets. This is particularly important in instruments such as the VTVM, oscilloscope and generator kits. Excessive heat will also burn or damage the insulating material used in the manufacture of switch assemblies. Be sure to use only good quality rosin core radio type solder.

Antenna General		Resistor General		Neon Bulb		Receptacle two-conductor	
Loop		Resistor Tapped		Illuminating Lamp		Battery	
Ground		Resistor Variable		Switch Single pole Single throw		Fuse	
Inductor General		Potentiometer		Switch double pole single throw		Piezoelectric Crystal	
Air core Transformer General		Thermistor		Switch Triple pole Double throw		1000 =	K
Adjustable Powdered Iron Core		Jack two conductor		Switch Multipoint or Rotary		1,000,000 =	M
Magnetic Core Variable Coupling		Jack three conductor		Speaker		OHM =	Ω
Iron Core Transformer		Wires connected		Rectifier		Microfarad =	MF
Capacitor General		Wires Crossing but not connected		Microphone		Micro Microfarad =	MMF
Capacitor Electrolytic		A. Ammeter V. Voltmeter		Typical tube symbol		Binding post Terminal strip	
Capacitor Variable		G. Galvanometer MA. Milliammeter uA. Microammeter, etc.				Wiring between like letters is understood 	

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